

5 concentric with said cylindrical die, an upper plunger, and a center pin concentric with said  
6 lower plunger for defining annular space within said die for molding powder into tubular  
7 configurations, as the plurality of the molding units are moved along a circular path;

8 a pair of pressure rollers provided at least at two equally spaced locations on the  
9 movement path of the plurality of molding units for pressure engagement with the upper plunger  
10 and the lower plunger, respectively, of each of said plurality of molding units;

C1 11 a feed station for loading each cylindrical die with a powder material to be  
12 molded by pressure engagement with the upper plunger and lower plunger into a pellet;

13 a plurality of operating units provided respectively to each of the plurality of  
14 molding units and moved along a concentric path with the molding units, for transferring and  
15 retractably positioning a case above and in alignment with the die of each of the molding units;  
16 and

17 an insertion assembly station mounted at an appropriate position on a movement  
18 path of the molding units for inserting the molded pellet into a case operatively positioned in  
19 alignment with the die by an operating unit.

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1 33. (Amended) The powder compression molding and assembly system according to  
2 Claim 32, wherein each of the operating units comprises an operating lever operatively  
3 connected to said cam follower, a support arm connected to said operating lever and rotatably  
C2 4 supported on the rotary disk, a case holding means mounted on said support arm, and a convey  
5 jig detachably supported on the case holding means, said convey jig supporting the cylindrical  
6 container such that an open end of the case faces downwards.

1           34.     (Amended) The powder compression molding and assembly system according to  
2 Claim 33, further comprising a support plate for closing and opening the open end of the case to  
3 prevent the pellet from falling out of the case.

1           35.     (Amended) The powder compression molding and assembly system according to  
2 Claim 29, wherein said pair of pressure rollers are provided at a plurality of locations  
3 corresponding to a number of the tubular configurations to be inserted into one case.

1           36.     (Amended) The powder compression molding and assembly system according to  
2 Claim 35, further comprising a means for supplying a plurality of cases one after another to each  
3 of the operating units, said means for supplying the cases being provided downstream of one of  
4 said pressure rollers in a direction of rotation of the rotary disk.

1           37.     (Amended) The powder compression molding and assembly system according to  
2 Claim 36, wherein the cases are supplied to the operating units as being held with respective  
3 convey jigs.

1           38.     (Amended) The powder compression molding and assembly system according to  
2 Claim 36, further comprising a means for receiving the cases one after another from each of the  
3 case holding means after a predetermined number of tubular configurations have been inserted  
4 into the cases, said means for receiving the cases being provided downstream of one of said  
5 pressure rollers in a direction of rotation of the rotary disk.

1           39.     (Amended) The powder compression molding and assembly system according to  
2 Claim 38, wherein the cases are transferred from the operating units to a next step as being held  
3 with respective convey jigs.

1           47.    (Amended) A powder compression molding and assembly system according to  
2 claim 29, wherein a plurality of the insertion assembly stations are provided so that the pellets  
3 formed at each of the molding units located between the insertion assembly stations are inserted  
4 into the case immediately after the compression molding at the next insertion assembly stations.

1           48.    (Amended) A powder compression molding and assembly system according to  
2 claim 47, wherein the insertion assembly station is provided in a pair, and further comprises:

3                   a case carrying-in means for feeding the cases into one insertion assembly station,  
4 a series of case holding means for holding and conveying the cases loaded with the pellet to  
5 another insertion assembly station; and

6                   a case carrying-out means for removing the cases after being loaded with the  
7 pellet at each insertion assembly station.

1           49.    (Amended) A powder compression molding and assembly system according to  
2 claim 49, wherein each of the case holding means is mounted on the rotary disk corresponding to  
3 each molding unit and is constructed to hold and retract the case loaded with the pellet at the first  
4 insertion assembly station to its retracted position beside the molding unit, and to advance the  
5 case to the movement path of the molding units at the next insertion assembly station.

1           50.    (Amended) A powder compression molding and assembly system according to  
2 claim 48, wherein the case is held by a conveyor member, which is conveyed and positioned by  
3 the actions of the case carrying-in means, the case holding means, and the case carrying-out  
4 means.

1           51.    (Amended) A powder compression and molding assembly system according to  
2 claim 48, wherein the case holding means is mounted to one end of an operating lever which is  
3 mounted on the rotary disk corresponding to each molding unit, the operating lever being  
C3 4 rotatably connected to the rotary disk with a cam follower at the other end thereof engaged with  
5 a cam disposed coaxially with the rotary disk, the cam having a retraction cam surface for  
6 holding the case holding means at its retracted position beside the molding unit and an operating  
7 cam surface for causing the case holding means to advance to and retract from the movement  
8 path of the molding unit.

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Please ~~add~~ the following newly drafted Claims 52-55:

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1           52.    (New) The powder compression molding and assembly system of Claim 29  
2 wherein the center pin extends into the dry cell housing container during the ejection of each  
3 molded tubular electrode pellet.

1           53.    The powder compression molding and assembly system of Claim 52 further  
2 comprising a first cam provided immediately downstream of the pair of pressure rollers in a  
C4 3 direction of rotation of the rotary disk, for lifting up the center pin and the lower plunger of the  
4 molding unit.

1           54.    (New) The powder compression molding and assembly system of Claim 53<sup>53</sup> further  
2 comprising a stationary second cam provided in coaxial arrangement with the rotary disk,  
3 wherein each of said plurality of operating units includes a cam follower for engagement with  
4 said second cam.

1 55. (New) The power compression molding and assembly system of Claim ~~56~~: 54

2 wherein said stationary second cam comprises a first cam surface for causing the  
3 operating units to track the concentric path with the molding units, and a second cam surface for  
4 causing the loading units to advance towards and between the upper plunger and the lower  
5 plunger of the molding units.

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